

Date: Monday, 03/11/2008 8:57:12 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE RH (209)
Job Number	: 43136		
Estimate Number	: 11597		
P.O. Number	:	Part Number	: D29172
This Issue	: 03/11/2008 S.O. No. :	Drawing Number	: D2917 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	:	Material	:
Written By	: <u>08.11.03</u>	Due Date	: 10/11/2008 Qty: 4 Um: Each
Checked & Approved By	:		
Comment	: Est A 04.07.16 New Issue KJ/JLM est B 07.08.07 ecn930 EC verified by: JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6102010 Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

6061-T6 8.25x7.95x2.5

Cut blanks: 2.500" x 8.250" x 7.950" grain along 7.950"

Material: 6061-T6/T651 (QQ-A-250/11)

(D6102-010)

Identify as D2917-2

Batch: B23641 X 3 PCSB37600 X 1 PCSJ.F. 08/11/06

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number

Machine Step No 1 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet

Machine Step No 2 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet

Machine Step No 3 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet

Deburr

J.F. 08/11/07PTO

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

J.F. 08/11/16

Process Sheet

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4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/11/16

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28/11/16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 08/11/17

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:30
320 °F
2:00

M-L 08/11/17

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-11-17

(X3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 4324

AS 08/11/18

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-11-18

Job Completion



DART AEROSPACE LTD	Work Order: 43/36
Description: Saddle RH	Part Number: D2917-2
Inspection Dwg: D2917 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.175	0.205		.188"	.191"	.190"	.190"		
B	0.090	0.110		.090"	.100"	.100"	.100"		
C	0.250	0.270		.263"	.254"	.259"	.259"		
D	1.599	1.619		1.608"	1.605"	1.608"	1.613"		
E	0.180	0.220		.180"	.180"	.180"	.180"		
F	0.277	0.297		.286"	.287"	.278"	.278"		
G	1.385	1.400		1.386"	1.378"	1.393"	1.391"		
H	3.170	3.230		3.205"	3.210"	3.210"	3.210"		
I	0.175	0.217		.196"	.175"	.192"	.194"		
J	0.470	0.530		R.500"	R.500"	R.500"	R.500"		
K	1.498	1.508		1.504"	1.499"	1.499"	1.499"		
L	4.436	4.446		4.441"	4.446"	4.438"	4.438"		
M	0.257	0.262	DT8683	Ø.258"	Ø.258"	Ø.258"	Ø.258"		
N	1.225	1.235		1.229"	1.231"	1.231"	1.231"		
O	1.103	1.113		1.107"	1.009"	1.009"	1.007"		
P	0.470	0.530		R.500"	R.500"	R.500"	R.500"		
Q	0.438	0.443	DT8682	Ø.442"	Ø.442"	Ø.442"	Ø.442"		
R	0.490	0.510		.503"	.516"	.503"	.503"		
S	1.745	1.755		1.752"	1.753"	1.753"	1.753"		
T	7.990	8.010		8.002"	8.004"	8.003"	8.003"		
U	3.495	3.505		3.500"	3.501"	3.501"	3.501"		
V	0.175	0.205		.200"	.175"	.195"	.195"		
W	1.990	2.010		2.001"	1.995"	2.006"	2.005"		
X	0.760	0.765		.760"	.760"	.760"	.760"		
Y	0.307	0.312		.310"	.310"	.310"	.310"		
Z	0.615	0.635		.631"	.633"	.630"	.635"		
AA	0.177	0.197		.184"	.187"	.187"	.187"		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JF
Date: 08/11/07

Audited by: LP
Date: 08/11/06

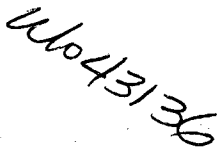
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2917-2 PAR #: N/A Fault Category: Prod Mach NCR: Yes No DQA: 12 Date: 08.11.18
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: 12 Date: 08/11/20

NCR: 43136		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/07	20	1.385" Bore is at 1.378" Ø.438 holes are shift on one side, so dimension	<i>[Signature]</i> 08/11/16	SCRAP SADDLE. PART IS DRILLED/ INSTALLED BY CUSTOMER AND WE CAN'T VERIFY FIT. 08.11.16	J.F. 08/11/07	<i>[Signature]</i> 08/11/16	<i>[Signature]</i> 08/11/17	<i>[Signature]</i> 08/11/17
		1.500 is at 1.516". R.C. Program on 4th axis is off.		R.C. Program	<i>[Signature]</i> 08.11.16	<i>[Signature]</i> 08/11/17		<i>[Signature]</i> 08/11/17

NOTE: Date & initial all entries



07.07.31 ~~4~~

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